

**Work Order ID 69427**

Wednesday, May 11, 2011 9:14:44 AM



Page 1

Item ID: D3913-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 5/11/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

|       |   |
|-------|---|
| D3913 | A |
|-------|---|

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D3913  
2- Drill hole as per dwg \*\*\*one side only\*\*\*  
3- remove identification marks and deburr

SAU 11-05-12

(3)

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Pl 11-05-13

120

Identify as per dwg &amp; Stock Location:

B/C

0.00



Packaging

Memo

0.00

Packaging

Pl 11-05-13

**Work Order ID 69427**

Page 2

Wednesday, May 11, 2011 9:14:44 AM

Item ID: D3913-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 5/11/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/10

ME

11-05-13

# Picklist Print

Wednesday, May 11, 2011 9:14:53 AM

Page 1  
T

Work Order ID: 69427



Parent Item: D3913-1

Parent Item Name: Rib

Start Date: 5/11/2011

Required Date: 5/17/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B  
add drill one side only DD 10.04.12 verified by:EC IPP Rev:C 11.01.18  
chg qc5 to 6 DD verf:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304TS0.750W.049

Purchased

No

100

f

214.5305

8

25.26316



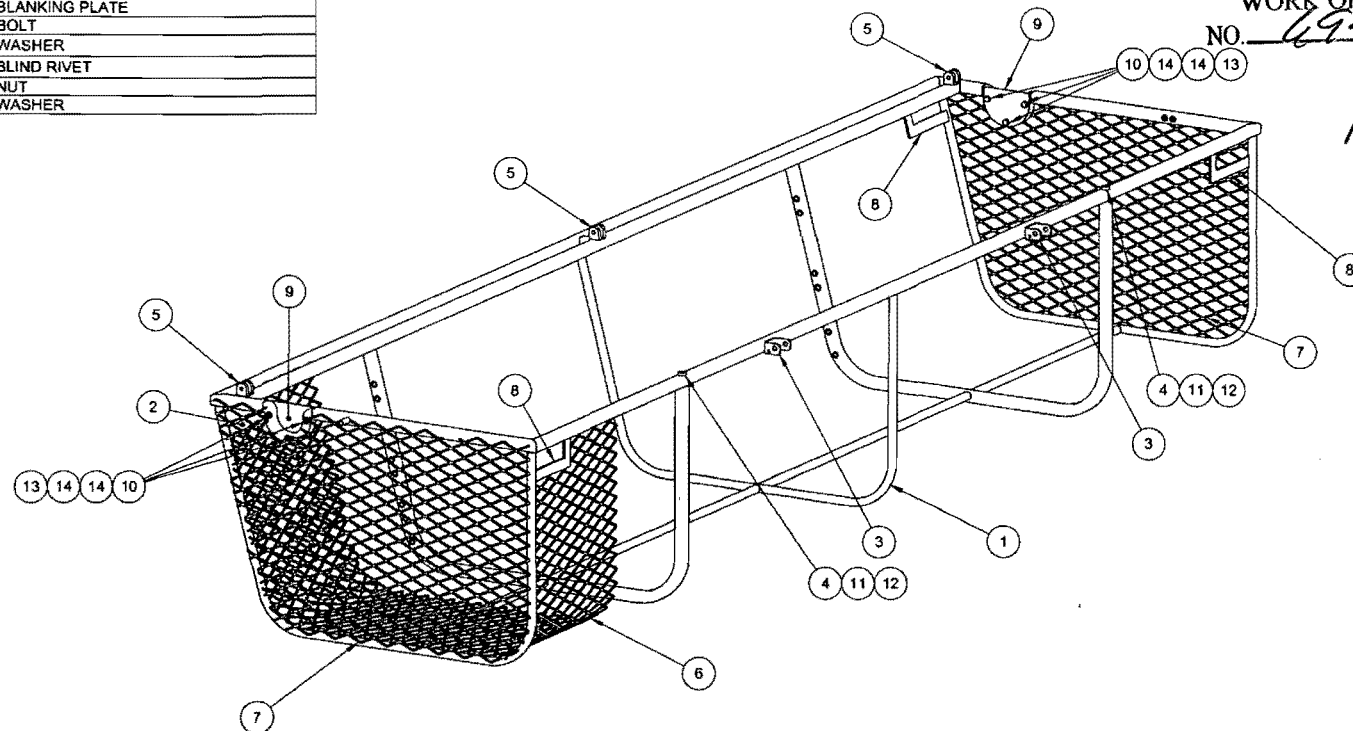
SAD 11-05-12

304 SQ Tube .75x.75x.049W

| Location | Loc Qty  | Loc Code |
|----------|----------|----------|
| MAT018   | 162.6414 |          |
| 117029   | 21.7849  |          |
| 117636   | 140.8565 |          |
| MAT034   | 51.8891  |          |
| 117337   | 51.8891  |          |

m117890 → 25.2632

| ITEM | QTY<br>-041 | P/N           | DESCRIPTION                     |
|------|-------------|---------------|---------------------------------|
|      | X           | D3913-041     | LONG BASKET BASE ASSY (350)     |
| 1    | 1           | D3913-101     | TUBULAR ASSY (350 SHORT BASKET) |
| 2    | 1           | D3913-15      | WIDE HANDLE PLATE               |
| 3    | 2           | D2581         | MOUNTING BRACKET                |
| 4    | 2           | D2931         | BUMPER                          |
| 5    | 3           | D4016-1       | HINGE HALF, BASE                |
| 6    | 1           | D4020-1       | MESH (350 BASKET LONG BASE)     |
| 7    | 2           | D4020-11      | END MESH, BASKET                |
| 8    | 3           | D4021-1       | HANDLE PLATE                    |
| 9    | 2           | D4021-5       | BLANKING PLATE                  |
| 10   | 6           | AN3-10A       | BOLT                            |
| 11   | 2           | AN960JD8      | WASHER                          |
| 12   | 2           | MS20600AD4W3  | BLIND RIVET                     |
| 13   | 6           | MS21042L3     | NUT                             |
| 14   | 12          | NAS1149F0332P | WASHER                          |



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

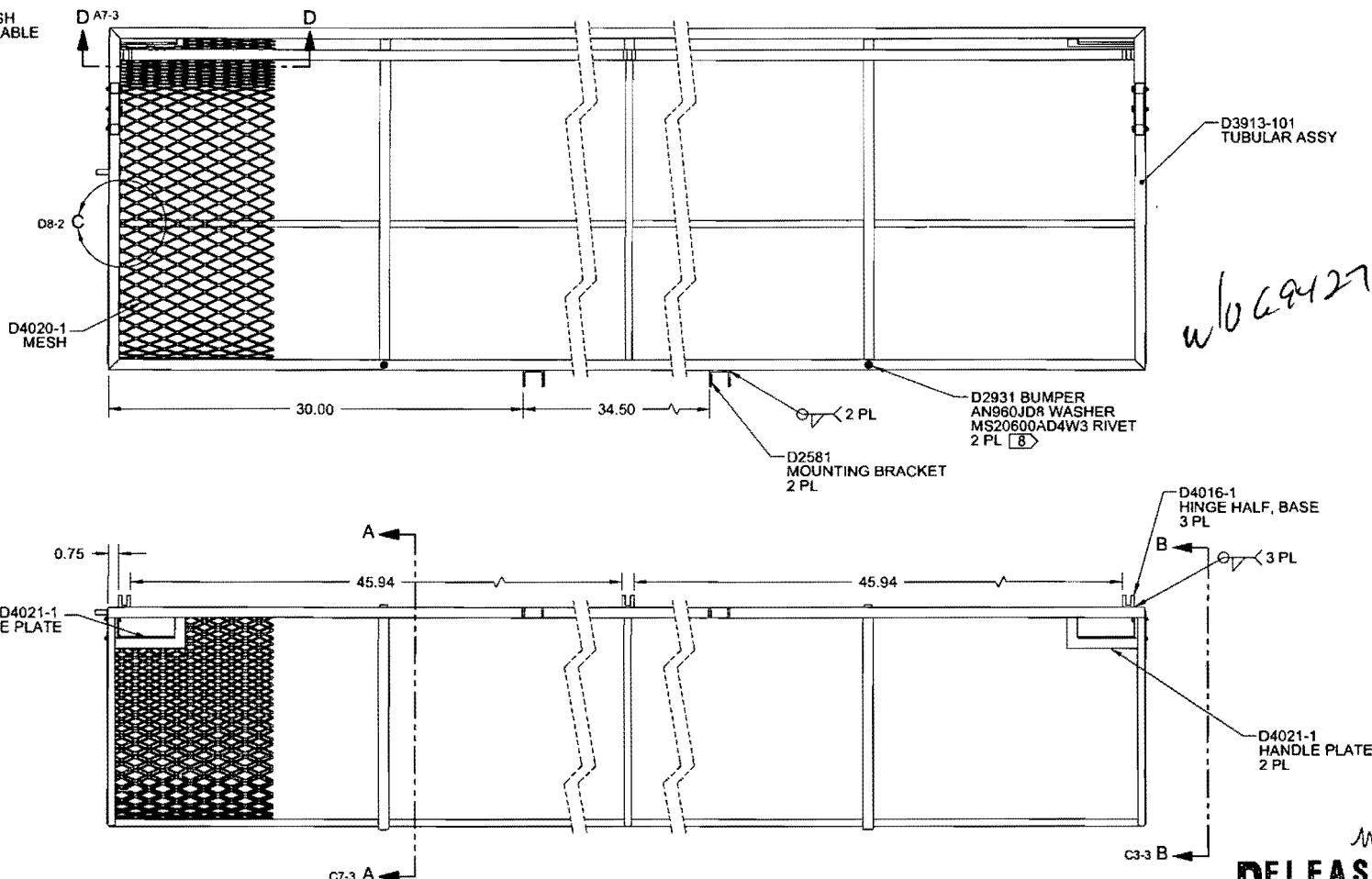
NO. 69427

**RELEASED**  
2010-03-22  
JWP

|   |             |     |          |
|---|-------------|-----|----------|
| A NEW ISSUE   |             | JPH | 10.03.16 |
| REV.  | DESCRIPTION | BY  | DATE     |
| DESIGN  | AJS         |     |          |
| DRAWN   | JFH         |     |          |
| CHECKED   |             |     |          |
| MFG. APPR.  |             |     |          |
| APPROVED  |             |     |          |
| DE APPR.  |             |     |          |
| DATE  | 10.03.16    |     |          |
| <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA<br>DRAWING NO. <b>D3913</b><br>TITLE <b>LONG BASKET BASE ASSY (350)</b><br>REV. A<br>SHEET 1 OF 6<br>SCALE<br>NTS<br>COPYRIGHT © 2010 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD |             |     |          |

TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION

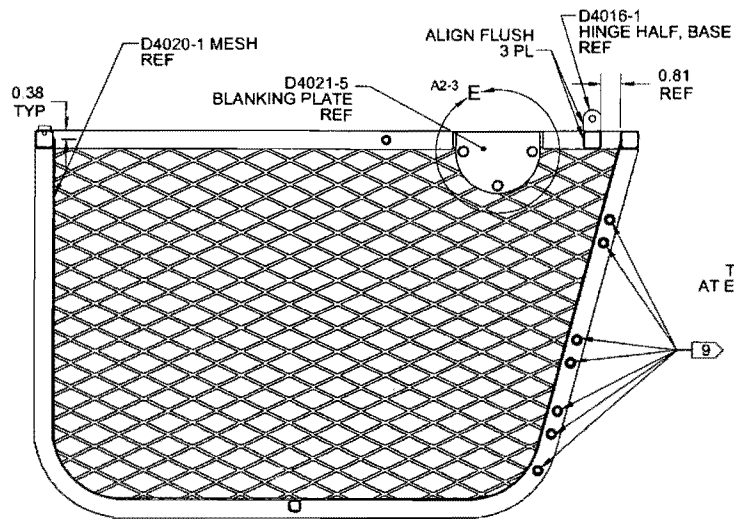
**DETAIL C** D7-2



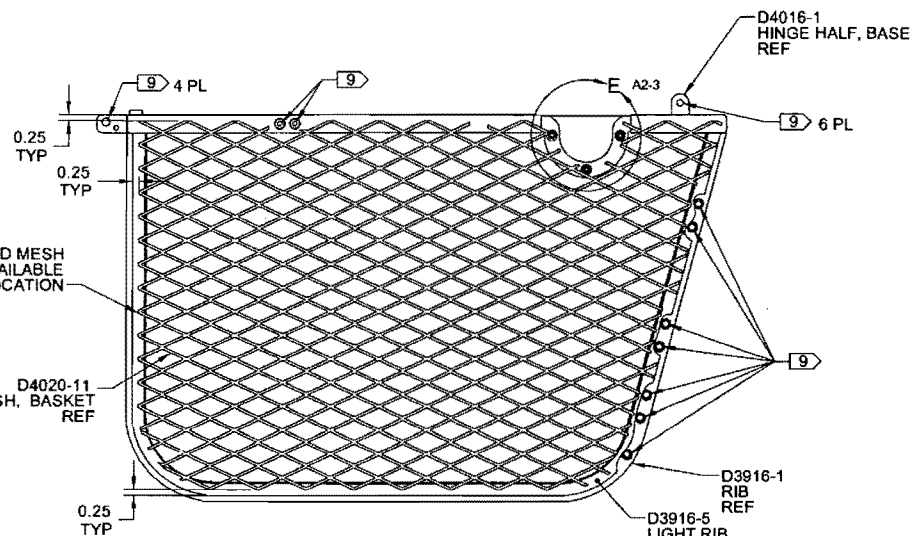
**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

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2010-03-27

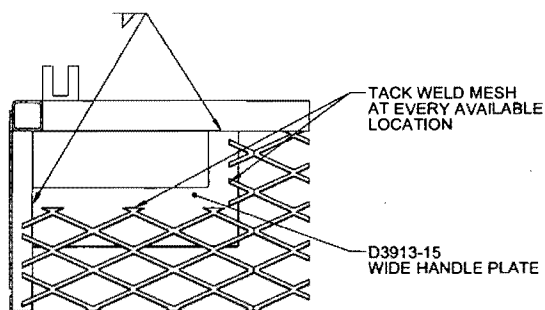
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|------------|----------|---|--------------|
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| DRAWN      | JPH      |   |              |
| CHECKED    |          | DRAWING NO.   | REV. A       |
| MFG. APPR. |          | D3913   | SHEET 2 OF 6 |
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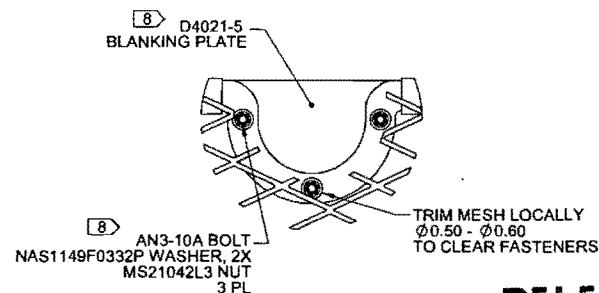
**SECTION A-A** A5-2



**VIEW B-B** A2-2



**SECTION D-D** D7-2  
TYPICAL FOR ALL  
HANDLE PLATES

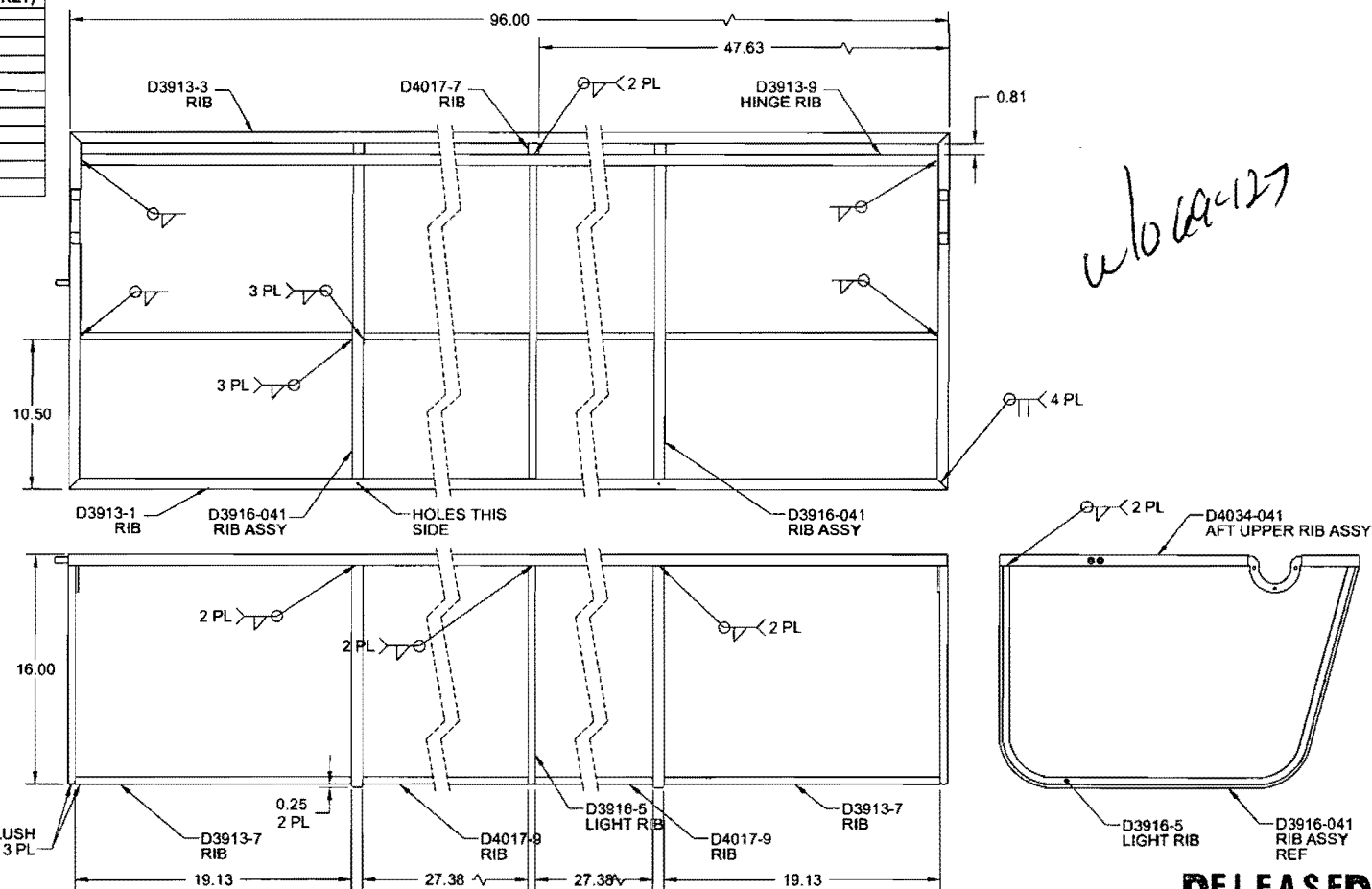


**DETAIL E** D2-3  
D6-3

|            |          |  |              |
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2010-03-22

| ITEM | QTY | P/N       | DESCRIPTION                    |
|------|-----|-----------|--------------------------------|
|      | X   | D3913-101 | TUBULAR ASSY (350 LONG BASKET) |
| 1    | 1   | D3913-1   | RIB                            |
| 2    | 1   | D3913-3   | RIB                            |
| 3    | 2   | D3913-7   | RIB                            |
| 4    | 1   | D3913-9   | HINGE RIB                      |
| 5    | 3   | D3916-5   | LIGHT RIB                      |
| 6    | 2   | D3916-041 | RIB ASSY                       |
| 7    | 1   | D4017-7   | RIB                            |
| 8    | 2   | D4017-9   | RIB                            |
| 9    | 1   | D4034-041 | AFT UPPER RIB ASSY             |
| 10   | 1   | D4034-043 | FWD UPPER RIB ASSY             |



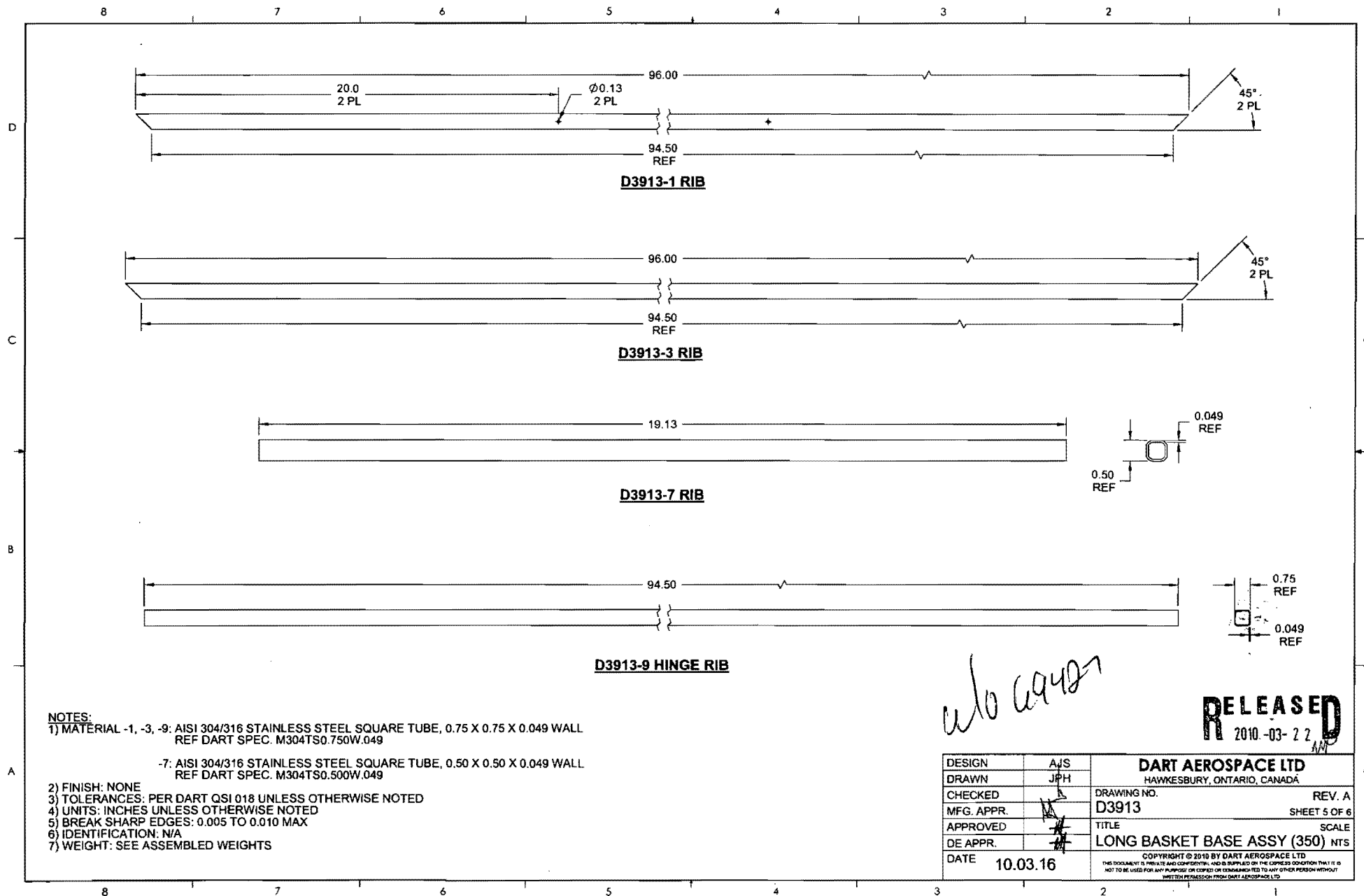
8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

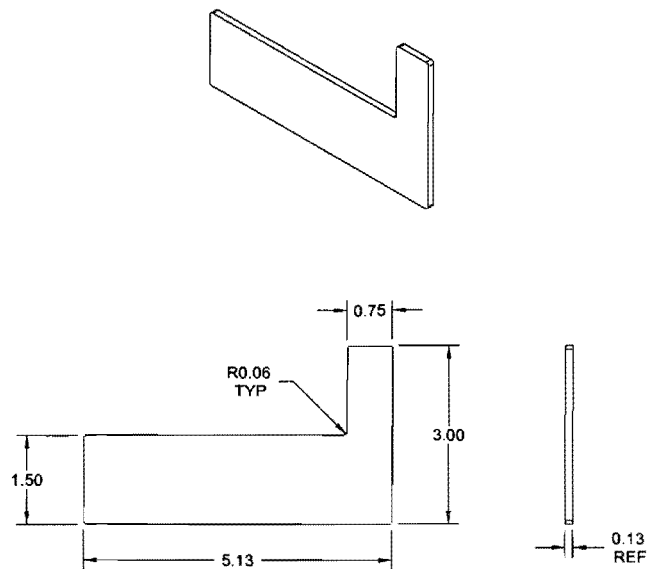
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D3913-101
- 9) WELD PER DART QSI 004

|            |          |   |              |
|------------|----------|---|--------------|
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| MFG. APPR. |          | D3913   | SHEET 4 OF 6 |
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**D3913-15 WIDE HANDLE PLATE**

**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

|            |                    |  |              |
|------------|--------------------|--|--------------|
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| MFG. APPR. | <i>[Signature]</i> |  | SHEET 6 OF 6 |
| APPROVED   | <i>[Signature]</i> | TITLE  | SCALE        |
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